



Manufacturers of Custom Welding Lines for Resale  
www.selectrode.com

# SELECTRODE 1168 Red Mild Steel

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1 E 6013  
DIN 1913: E 5122 R C 3  
NFA 81-309: E 512/2 R 12

EN 499: E 420 RC 11  
ISO 2560 E 51.2RR22  
BS 619: E 5122 R 12

## FEATURES & APPLICATIONS

Versatile all around repair and fabrication of clean, well fitting common mild steel components. Fast freeze slag characteristics ensures fully positional operability.

Universal all position mild steel electrode available in a variety of colors

- Only mild steel electrode offering the convenience of flat , vertical up and down, and overhead without changing amperage setting.
- Four (4) colors kept in stock at all times Tan (1160), Blue (1159), Gold (1155) and Red (1168).
- Electrode can be bent without flux breakage.
- Contact (drag) type transfer allows the electrode to weld by itself.
- Also available as a torch fusion alloy as item #2161, a TIG alloy as item #6006, a solid MIG alloy as item #7070 and a flux cored MIG alloy as item #7160 and a gasless flux cored MIG alloy as item #7166.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Color:** Tan, Blue, Gold or Red or custom colors on request

C	Mn	V	Si	Mo	S	Ni	P	Cr	Fe
.08	.5	.08	.2	.30	.01	.30	.02	.20	Bal.

## TYPICAL MECHANICAL PROPERTIES

### Undiluted Weld Metal

Tensile Strength  
Yield Strength  
Elongation  
Impact Energy

### Maximum Value Up to:

83,000 psi (600 MPa)  
75,000 psi (540 MPa)  
25%  
90J: -4°F (-20°C)

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Straight (-), Reverse (+) or AC

Diameter (mm)	1/16 (1.6)*	5/64 (2.0)*	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	20	30	50	70	115	150
Maximum Amperage	40	50	70	110	140	200

**Welding Techniques:** Hold a short to medium arc length, lean electrode 45° towards the direction of travel. Use either the stringer or weave technique.

**Welding Positions:** Flat, vertical up, vertical down, horizontal, overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
1/16 (1.6)*	12" (300)	.11oz (3g)	145 (320)	57 (125)	30
5/64 (2.0)*	12" (300)	.14oz (4g)	114 (251)	47 (103)	40
3/32 (2.5)	14" (350)	.30oz (8g)	53(117)	36 (79)	60
1/8 (3.2)	14" (350)	.62oz (17g)	26 (57)	25 (55)	90
5/32 (4.0)	14" (350)	1oz (28g)	16 (35)	20 (44)	125
3/16 (5.0)*	14" (350)	1.5oz (42g)	11 (23)	14 (31)	175

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)*	5/64 (2.0)*	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)*
Length (mm)	12" (300)	12" (300)	14" (350)	14" (350)	18" (450)	18" (450)
Electrodes / lb	60	42	25	15	10	7
Electrodes / kg	132	92	55	33	22	15

\*Only stocked in certain colors